

# Work Order ID 51958

September 10, 2009 2:54:17 PM

Page 1

Item ID: D2849-2

Revision ID: A

Item Name: End Bracket

Start Date: 9/11/09

Start Qty: 8.00 *ONLY*

Required Date: 9/18/09

Req'd Qty: 8.00

Reference:

Approvals:

Process Plan: *[Signature]*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2849

Rev A

100



Shear

Shear

SHEAR

Memo

blanks: 3.8"

0.00

0.00

*DT 09/09/29*

8

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine per Folio D2849-2 Deburr and Tumble

0.00

0.00

*DT 09/09/29*

8

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*DT 09/09/29*

8

125

QC 8

*DT 09/09/29*

8

0

*09/09/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51958

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Page 2

Item ID: D2849-2

Accept

Revision ID: A

Item Name: End Bracket

Start Date: 9/11/09 Start Qty: 8.00

Required Date: 9/18/09 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

PAKE

PC 9/9/30 (8)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/01

MF 09-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 10, 2009 2:54:16 PM

Page 1

Work Order ID: 51958

Parent Item: D2849-2RevA

Parent Item Name: End Bracket

Comments:

Start Date: 9/11/09

Required Date: 9/18/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.500X01.50 0		Purchased	No			100	f	38.1932	2.7015			



6061-T6 Bar 2.50 x 1.50



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	38.1932	
100947	2.1932	
16742	36	
M116716		

2.7015 DA 09/09/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

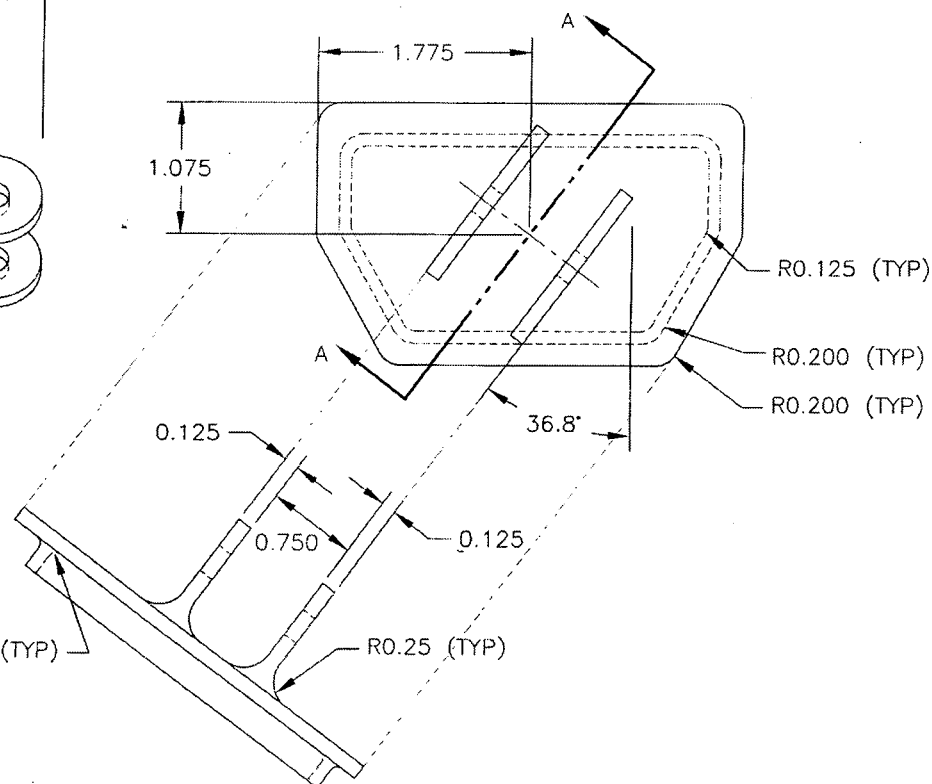
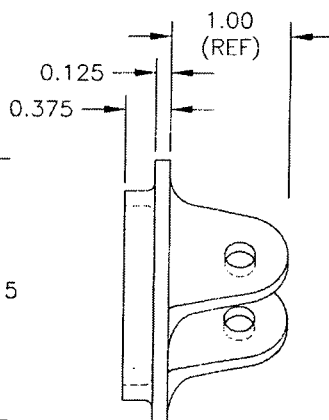
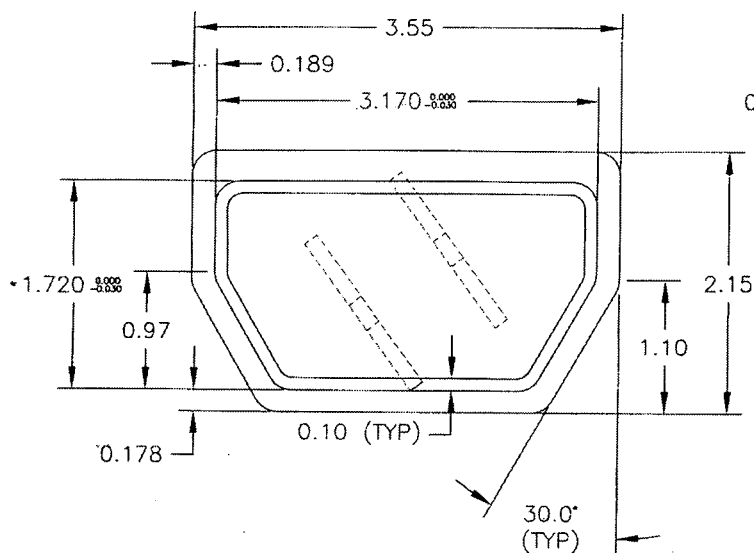
DART AEROSPACE LTD		Work Order: 51958
Description: End Bracket		Part Number: D2849-2
Inspection Dwg: 2849-2 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.55	$\pm 0.030$	3.547	✓			
0.189	$\pm 0.010$	0.180	✓			
3.170	$+0.000/-0.030$	3.170	✓			
1.720	$+0.000/-0.030$	1.720	✓			
0.97	$\pm 0.030$	0.97	✓			
0.178	$\pm 0.010$	0.170	✓			
0.10	$\pm 0.030$	0.099	✓			TYP
30°	$\pm 1/2^\circ$	30°	✓			
1.10	$\pm 0.030$	1.10	✓			
2.15	$\pm 0.030$	2.151	✓			
1.00	$\pm 0.030$	0.998	✓			REF
0.125	$\pm 0.010$	0.118	✓			
0.375	$\pm 0.010$	0.370	✓			
1.775	$\pm 0.010$	1.775	✓			
1.075	$\pm 0.010$	1.075	✓			
36.8°	$\pm 1/2^\circ$	36.8	✓			
0.125	$\pm 0.010$	0.135	✓			
0.750	$\pm 0.010$	0.750	✓			
0.125	$\pm 0.010$	0.135	✓			
R0.25	$\pm 0.030$	0.250	✓			TYP
Ø0.257	$+0.006/-0.001$	0.259	✓			
R0.400	$\pm 0.010$	0.400	✓			
0.600	$\pm 0.010$	0.603	✓			
13°	$\pm 1/2^\circ$	13°	✓			
Measured by: DJP	Audited by: SP		Prototype Approval:		N/A	
Date: 09/09/29	Date: 09/09/29		Date:		N/A	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D2849-1 (SHOWN)

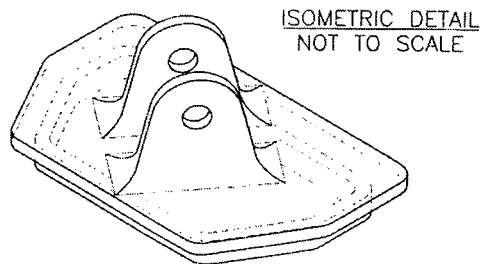
D2849-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

FINISH: NONE

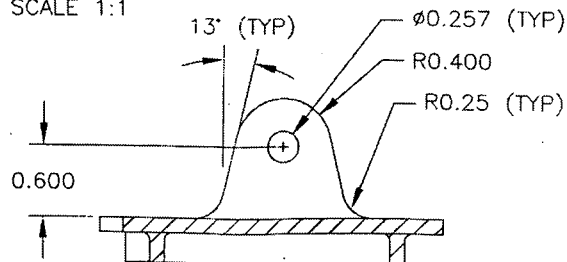
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL  
NOT TO SCALE

SECTION A-A  
SCALE 1:1



RELEASED



A	98.11.10	NEW ISSUE, REPLACES D2358 REV. B AND D2359 REV. A	
DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED KE	APPROVED PP	DRAWING NO. D2849	REV. A SHEET 1 OF 1
DATE 98.11.10	TITLE LOW FLOAT STEP END BRACKET		SCALE 1:1



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